

Date: Tuesday, 11/6/2007 1:38:14 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : 02.250 SUPPORT

Job Number : 35580

Estimate Number : 11057

P.O. Number

This Issue : 11/6/2007

S.O. No. :

Prsht Rev. : NC

First Issue : 1/1

Type : PURCHASED PARTS

Previous Run : 34062

Part Number : D28911

Drawing Number : D2891 REV A1

Project Number : N/A

Drawing Revision : A1

Material

Due Date : 12/13/2007

Qty: 10 Um: Each

Written By

Checked & Approved By

Comment : Est. C 02.11.26 Added P/O KJ

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description :

1.0

PG

PURCHASING

Comment: PURCHASING

Issue P/O: 4996

Description: D6104-003

Material: 17-4 PH SS (AMS 5643 OR AISI 630) as per Dwg D6104

Material release note required.

Blank size makes (2) D2891-1

HT# 19095

(10) B 35580

24 08/03/27

2.0

D6104003

17-4 SS Roundbar 3.25"OD

Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Support 2.25 dia

3.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0

MORI SEIKI D005AU

MORI SEIKI CNC LATHE LARGE

Comment: MORI SEIKI LATHE

Turn blank for Haas as per Folio FA046

5.0

QC1

INSPECT ALL DIM TO DIM SHEET

Comment: INSPECT ALL DIM TO DIM SHEET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/6/2007 1:38:14 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.250 SUPPORT

Job Number: 35580

Part Number: D28911

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

Machine as per Folio FA046

Tumble & Deburr

J.L. / BG 08-05-01

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L. / BG 08-05-01

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SS 08/05/10

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

SS 08-05-06

S.21

1.30

#1

406.0

F

#2

0.00

F

#3

F

#4

F

35580

28911

10/05/2008

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 08/05/08

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

ml 08 05 08

(20)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/12

Job Completion



mf 08-05-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 35580
Description: Ø2.250 Support	Part Number: D2891-1
Inspection Dwg: D2891 Rev. A1	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2891 Rev.A1/DSK076 Rev.A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	2.274	2.279		2.275	2.279	2.279	2.279		
B	3.702	3.722		3.710	3.710	3.710	3.710		
C	2.564	2.584		2.575	2.575	2.575	2.575		
D	0.718	0.738		.728	.728	.728	.728		
E	0.090	0.110		.100	.100	.100	.100		
F	2.464	2.484		2.474	2.474	2.474	2.474		
G	2.029	2.049		2.039	2.039	2.039	2.039		
H	2.964	2.984		2.975	2.975	2.975	2.975		
I	0.913	0.933		.923	.923	.923	.923		
J	0.022	0.042		.03	.03	.03	.03		
K	0.090	0.110		.100	.100	.100	.100		
L									
HAAS Section									
AA	0.188	0.193	DT8706	.189	.189	.189	.189		
AB	0.240	0.260		.252	.252	.251	.250		
AC	0.115	0.150		.124	.125	.124	.124		
AD	0.040	0.060		.051	.052	.053	.053		
AE	0.010	0.020		.015	.015	.015	.015		
AF	0.240	0.260		.250	.250	.250	.250		
AG	0.290	0.310		.310	.310	.310	.310		
AH	0.115	0.150		.137	.137	.136	.136		
AI	0.454	0.474		.462	.460	.457	.459		
AJ	2.779	2.789		2.784	2.784	2.784	2.784		
AK	0.240	0.260		.250	.250	.250	.250		
AL	1.002	1.042		1.034	1.036	1.036	1.038		
AM	0.053	0.073		.063	.063	.063	.063		
AN	0.257	0.262	DT8683	.258	.258	.258	.258		
AO	1.663	1.683		1.675	1.671	1.673	1.672		
AP	0.053	0.073		.063	.063	.063	.063		
AQ	0.022	0.042		.032	.032	.032	.032		
AR									
AS									
Accept/Reject									

Measured by:	J.P. 08/03/07
Date:	

Audited by:	L.P. 08/05/10
Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	#

DART AEROSPACE LTD	Work Order: 35580
Description: Ø2.250 Support	Part Number: D2891-1
Inspection Dwg: D2891 Rev. A1	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2891 Rev.A1/DSK076 Rev.A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	2.274	2.279		2.279	2.279	2.279	2.279		
B	3.702	3.722		3.710	3.710	3.710	3.710		
C	2.564	2.584		2.575	2.575	2.575	2.575		
D	0.718	0.738		.728	.728	.728	.728		
E	0.090	0.110		.100	.100	.100	.100		
F	2.464	2.484		2.474	2.474	2.474	2.474		
G	2.029	2.049		2.039	2.039	2.039	2.039		
H	2.964	2.984		2.974	2.974	2.974	2.974		
I	0.913	0.933		.923	.923	.923	.923		
J	0.022	0.042		.03	.03	.03	.03		
K	0.090	0.110		.100	.100	.100	.100		
L									
HAAS Section									
AA	0.188	0.193	DT8706	.189	.189	.189	.189		
AB	0.240	0.260		.251	.251	.250	.251		
AC	0.115	0.150		.125	.124	.124	.125		
AD	0.040	0.060		.052	.050	.051	.051		
AE	0.010	0.020		.015	.015	.015	.015		
AF	0.240	0.260		.250	.250	.250	.250		
AG	0.290	0.310		.310	.310	.310	.310		
AH	0.115	0.150		.138	.138	.138	.138		
AI	0.454	0.474		.462	.464	.464	.463		
AJ	2.779	2.789		2.784	2.784	2.784	2.784		
AK	0.240	0.260		.250	.250	.250	.250		
AL	1.002	1.042		1.039	1.041	1.038	1.037		
AM	0.053	0.073		.063	.063	.063	.063		
AN	0.257	0.262	DT8683	.258	.258	.258	.258		
AO	1.663	1.683		1.673	1.673	1.675	1.673		
AP	0.053	0.073		.063	.063	.063	.063		
AQ	0.022	0.042		.032	.032	.032	.032		
AR									
AS									
Accept/Reject									

Measured by: <i>RL</i>
Date: <i>08/03/27/J.L</i>

Audited by: <i>SL</i>
Date: <i>08/05/10</i>

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF <i>TF</i>	<i>+</i>

DART AEROSPACE LTD	Work Order: 35580
Description: Ø2.250 Support	Part Number: D2891-1
Inspection Dwg: D2891 Rev. A1	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2891 Rev.A1/DSK076 Rev.A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	2.274	2.279		2.279	2.279				
B	3.702	3.722		3.710	3.710				
C	2.564	2.584		2.574	2.574				
D	0.718	0.738		.728	.728				
E	0.090	0.110		.100	.100				
F	2.464	2.484		2.474	2.474				
G	2.029	2.049		2.039	2.039				
H	2.964	2.984		2.975	2.975				
I	0.913	0.933		.923	.923				
J	0.022	0.042		.03	.03				
K	0.090	0.110		.100	.100				
L									
HAAS Section									
AA	0.188	0.193	DT8706	.188	.188				
AB	0.240	0.260		.250	.250				
AC	0.115	0.150		.140	.140				
AD	0.040	0.060		.050	.050				
AE	0.010	0.020		.015	.015				
AF	0.240	0.260		.250	.250				
AG	0.290	0.310		.300	.300				
AH	0.115	0.150		.140	.140				
AI	0.454	0.474		.464	.464				
AJ	2.779	2.789		2.784	2.784				
AK	0.240	0.260		.250	.250				
AL	1.002	1.042		1.040	1.040				
AM	0.053	0.073		.063	.063				
AN	0.257	0.262	DT8683	.257	.257				
AO	1.663	1.683		1.673	1.673				
AP	0.053	0.073		.063	.063				
AQ	0.022	0.042		.032	.032				
AR									
AS									
Accept/Reject									

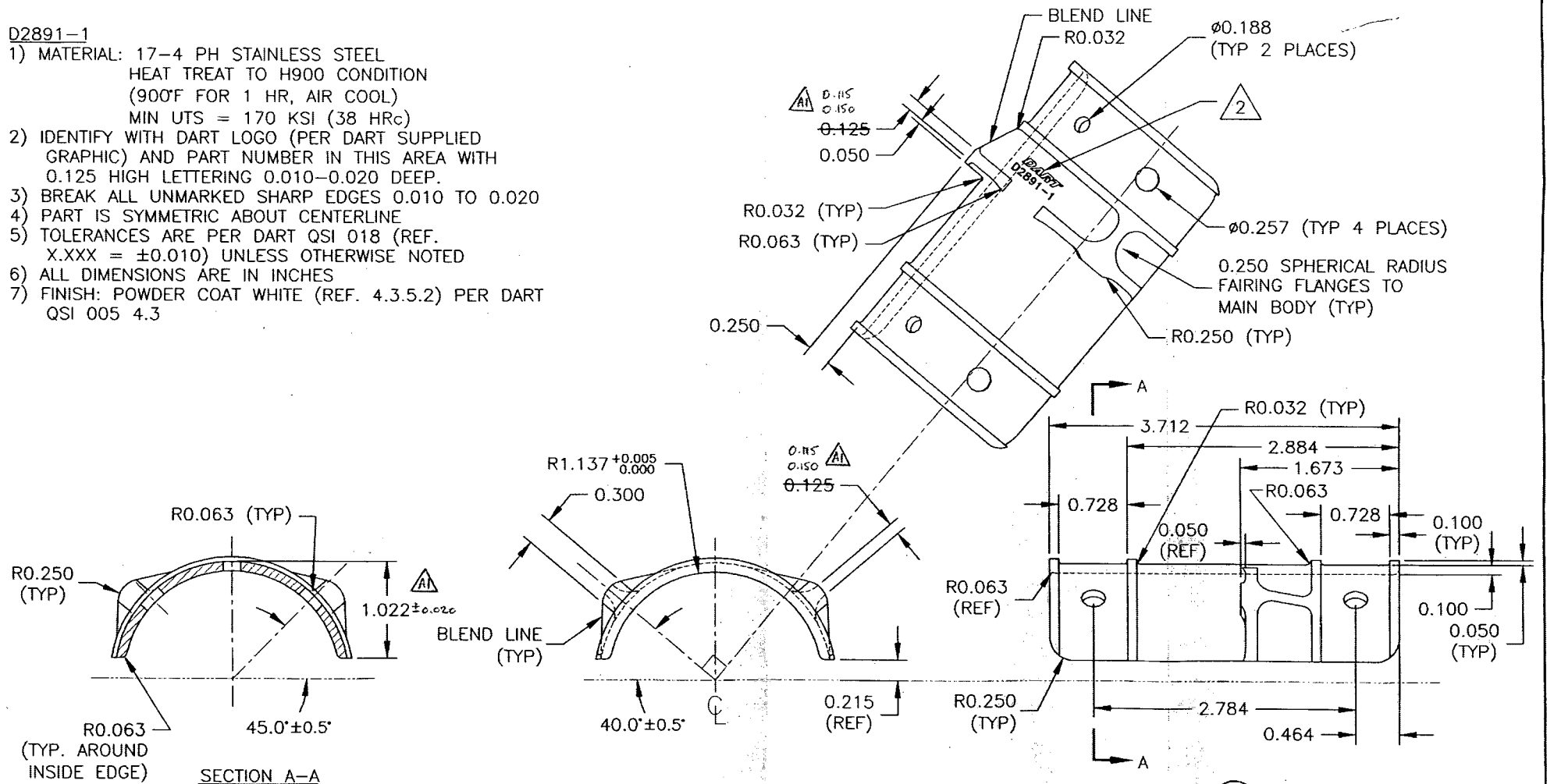
Measured by: <i>122</i>
Date: <i>08/03/27</i>

Audited by: <i>SB</i>
Date: <i>08/04/27</i>

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF <i>[initials]</i>	<i>[initials]</i>

D2891-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRc)
- 2) IDENTIFY WITH DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP.
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3



NO. 3580
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

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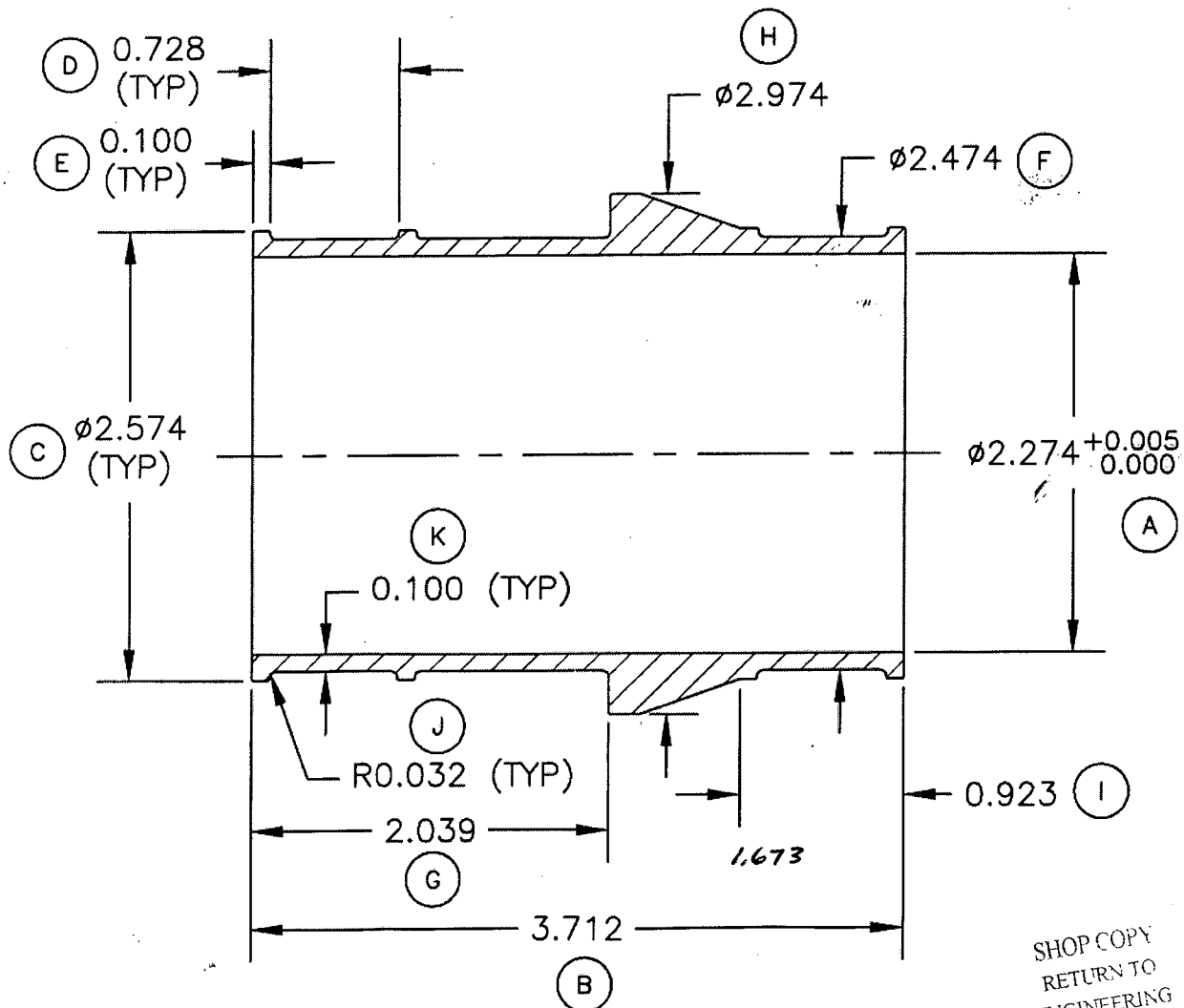
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AI	CP	02.01.23	UPDATE DIMS AS MANUFACTURED
A		00.11.17	NEW ISSUE
DESIGN	CP	DRAWN BY	CP
CHECKED	#	APPROVED	#
DATE	00.11.17	DRAWING NO.	D2891
		TITLE	Ø2.250 SUPPORT
		REV. A	SHEET 1 OF 1
		SCALE	1:1

DART DART AEROSPACE LTD.
HARRISBURG, ONTARIO, CANADA

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 076	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2891-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01 [Signature]**D2891-1 TURNING DETAIL**

SHOP COPY
RETURN TO
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WORK ORDER
NO. 35580

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T-082 P004/010 F-406
514-695-3281
29-11-07 09:57 FROM-metaux castle

559385 396130 10		Métaux Castle®		A.M. CASTLE & Co. (Canada) Inc.		DATE CHARGED-LOADED EXPÉDIÉ 27 NOV 2002		NO. COM-CPD. NO. 559385		POIDS TOTAL (KGS) NET WT. DLY. W.							
QUISITION CLIENT-CUSTOMER REQUISITION NO.				NO. COM. CLIENT-CUST. ORD. NO. 4998		COMPT. ACCT. VEND. S.S. TERR. EXPÉDIÉ PAR-SHIP VIA 71037 200 40 USUAL MAILTOLA											
EUR-PURCHASING AGENT NDA LABELLE				TELEPHONE 613 632-3326		H/C TAXE NO. COM-CPD 9 0 1		REGION LIVRAISON-DEL. ZONE C/C		F.A.B.-F.O.B. PREPAID							
A-SHIP TO:				VENDU A-SOLD TO: DART AEROSPACE LTD 1270 ABERDEEN HAMKESBURY ON K6A 1K7				INFORMATION CRÉDIT-CREDIT INFORMATION R2C SEE FRANCE STATUS		ROUTE 10-NL-11/19 30-NL-11/21 31-NL-11/23							
INSTRUCTIONS LIVRAISON-DELIVERY G-363301				INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONTD.)				INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONTD.)									
OPTION - ITEM 1 2500 RD 17CR-4NI RT SOL. TREATED COND A 3.80" GOLD										QTE/UNITE COM-ORDERED 20 PCS PCS		POIDS COM.-WT. ORDERED 179					
CERTIFICAT DE CONFORMITE See Packing Slip for English Certificate of Conformance 1. Castle & Co. (Canada) Inc. certifie que la material fourni prés ce document rencontrera et est conforme aux ifications du produit(s) décrit(s) ci-contre. A.M. Castle & Co. (Canada) Inc.				INSTRUCTIONS FILL FROM ONE HEAT ONLY TOL + 1/16" -0" PRIOR DIST/ORD: 10 396130				COULÉE INFO-HEAT INFO QTE-QTY A19095 ✓ 10 A18939 ✓ 10		BALLOTS-BUNDLES 1 20 179		PCES/PO EXP. SHIP POIDS EXP.-WT. SHIPPED					
IDS POUR EXPEDITION SEULEMENT. VOIR FRACTURE UR LE POID EXACT FRACTURE. SVP SIGNER ET TER LA COPIE DU CHAUFFEUR POUR RÉCEPTION DU TERIAL ET, SI VÉRIFIÉ, CERTIFICAT D'ANALYSE.								INSTRUCTIONS (CONTD.) 20x380		FORME-SHAPE I.A.C. 42470		ENT.-WHS 4					
OPTION - ITEM 2 TERMES ET CONDITIONS DE VENTES DESABEU DES GARANTIES ET RESTRICTION DE RESPONSABILITE AU VERSO										INSTRUCTIONS 1 box				COULÉE INFO-HEAT INFO QTE-QTY		QTE/UNITE COM. ORDERED BALLOTS-BUNDLES PCES/PO EXP. SHIP POIDS COM.-WT. ORDERED POIDS EXP.-WT. SHIPPED	
OPTION - ITEM 3 LES DIFFÉRENCES OU DOMMAGES DOIVENT ÊTRE INDICUÉS LA COPIE REÇUE LIVRAISON ET LA FEUILLE D'EMBALLAGE ET IE PAR LE CHAUFFEUR ET LE CLIENT. UNE COPIE DE CE REÇU ENT INDICUÉ DOIT ÊTRE SOUMIS DANS LES 15 JOURS SQU'UN CRÉDIT EST REÇU.										INSTRUCTIONS				COULÉE INFO-HEAT INFO QTE-QTY		QTE/UNITE COM. ORDERED BALLOTS-BUNDLES PCES/PO EXP. SHIP POIDS COM.-WT. ORDERED POIDS EXP.-WT. SHIPPED	
LETTRE NOUVEAU-NOME (PRINT ONLY)										INSTRUCTIONS (CONTD.)				FORME-SHAPE I.A.C.		ENT.-WHS	
U PAR-RECEIVED BY										DATE RECIE							



P.O. BOX 977
SYRACUSE
NEW YORK 13201

CERTIFICATE OF TEST

A M CASTLE, INC

SHIP A M CASTLE, INC

OUR ORDER NO.
PS-16226-7-01

3400 N WOLF RD

26800 MILES RD

FRANKLIN PARK, IL 40131

BEDFORD HEIGHTS OH 44146

11 11/01/07

CUSTOMER ORDER # & DATE
10-34264

CUSTOMER REQ. #

DISTRICT

B PARSONS

SHIPPED
FROM

SYRACUSE

DESCRIPTION OF MATERIAL

SIZE

GRU 17-4PH RT A IAC 42470

3.250 RD

AMS-3174-02 REV 26 ASME-SAS64-07ED T630 ASTM-A564-04 T630

AMS-2703E AMS-5643Q (EX SURF) AISI 630 UNS-S17400

HEAT NO.

CHEMICAL ANALYSIS

HEAT NO.	C	MN	P	S	SI	NI	CR	MO	CU	CB	TA
A19095	.039	.46	.029	.026	.66	4.23	15.22	.13	3.20	.31	.010

CASTLE METALS CORP

DATE RCVD 11/2/07

IAC 42470

APPROVED BY

QUANTITY

HEAT NO.

MECHANICAL PROPERTIES

981 2 A19095

HARDNESS
BHN 358

CAPABILITY PHYSICALS AFTER 900 DEG. F. - 1 HR. AIRCOOL:

199,390

176,620

12.6

50.2

BHN 401

MACRO TEST OK

FERRITE 5.5%

MAGNAFLUX F/S = 0/0

ELECTRIC FURNACE ADD MELTED

REDUCTION RATIO: 27.5:1

MATERIAL SOLUTION TREATED AT 1900 DEG. F. HELD 45 MIN

AT TEMPERATURE -

AIRCOOLED.

CRUCIBLE MATERIALS CORP. VENDOR #18610.

MATERIAL INGOT CAST.

NAPTA - YES

CORRECTED COPY ORIGINAL SENT 10/17/07

MATERIAL FREE FROM MERCURY CONTAMINATION AT TIME OF SHIPMENT

NO WELD REPAIR PERFORMED

MATERIAL MELTED IN U.S.A.

MANUFACTURED BY THE EMPLOYEES OF CRUCIBLE SPECIALTY METALS

THANK YOU FOR SELECTING A QUALITY PRODUCT

SWORN TO AND SUBSCRIBED BEFORE ME THIS

DAY OF . 20

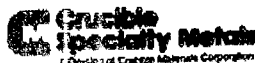
NOTARY PUBLIC

JACKIE L. WHITE - SPECIFICATION EXAMINER

THE ABOVE MATERIAL WAS MANUFACTURED AND TESTED IN ACCORDANCE
WITH ABOVE SPECIFICATIONS AND IS IN CONFORMANCE WITH THOSE
SPECIFICATION REQUIREMENTS.

CERTIFIED
BY:

CRUCIBLE MATERIALS CORPORATION
ACTING BY AND THROUGH ITS SPECIALTY METALS DIVISION
QUALITY ASSURANCE REPRESENTATIVE



P.O. BOX 977
SYRACUSE
NEW YORK 13201

CERTIFICATE OF TEST

S
H
I
P
T
O

A H CASTLE, INC

S
H
I
P
T
O

A H CASTLE, INC

3400 N DOLF RD

26800 MILES RD

FRANKLIN PARK, IL 60131

BEDFORD HEIGHTS OH 44146

95

OUR ORDER NO.

PS-11330-7-0

DATE

07/16/07

CUSTOMER ORDER # & DATE

10-31163

CUSTOMER REQ. #

DISTRICT

S FARSONS

SHIPPED FROM

SYRACUSE

DESCRIPTION OF MATERIAL

SIZE

3.250 RD

CRW 17-4PH RT A IAC 42470

AMC-3174-10 REV 7

ASME-SA564-04ED T630

ASTM-A564-04 T630

AMS-56430 AISI 630 UNS-S17400

CHEMICAL ANALYSIS

HEAT NO.

A18939

C
.037MN
.42P
.027S
.022SI
.63NI
4.09CR
15.28ND
.11CU
3.22CB
.29TA
.012

CASTLE METALS CORP.

DATE RCVD 7/25/07

IAC 42470

APPROVED BY *[Signature]*

MECHANICAL PROPERTIES

QUANTITY

HEAT NO.

1311 & A18939

TENSILE PSI YLD.2XFSI

XELONG4D

RED/AREAX

HARDNESS

BHN 356

CAPABILITY PHYSICALS AFTER 900 DEG. F. - 1 HR. AIRCOOL:

203,000

174,000

12.3

51.1

BHN 415

MACRO TEST OK
FERRITE 3 %
MAGNAFLUX F/S = 0/0

REDUCTION RATIO: 27.5:1

MATERIAL SOLUTION TREATED AT 1900 DEG. F. HELD 45 MINUTES AT TEMPERATURE -

AIRCOOLED.

CRUCIBLE MATERIALS CORP. VENDOR #15510.

MATERIAL INJECT CAST.

NAFTA - YES

MATERIAL FREE FROM MERCURY CONTAMINATION AT TIME OF SHIPMENT
NO WELD REPAIR PERFORMED
MATERIAL MELTED IN U.S.A.

THANK YOU FOR SELECTING A QUALITY PRODUCT
MANUFACTURED BY THE EMPLOYEES OF CRUCIBLE SPECIALTY METALS

THE ABOVE MATERIAL WAS MANUFACTURED AND TESTED IN ACCORDANCE WITH ABOVE SPECIFICATIONS AND IS IN CONFORMANCE WITH SPECIFICATION REQUIREMENTS.

CRUCIBLE MATERIALS CORPORATION
ACTING BY AND THROUGH ITS SPECIALTY METALS DIVISION

SWORN TO AND SUBSCRIBED BEFORE ME THIS

DAY OF _____, 20

CERTIFIED BY: *[Signature]*

QUALITY ASSURANCE REPRESENTATIVE

NOTARY PUBLIC